

Work Order ID 70437

Wednesday, June 08, 2011 9:16:11 AM



Item ID: D3210-1B

Accept



Revision ID: PRELIM

Item Name: Doubler

Start Date: 6/8/2011 Start Qty: 1.00



Required Date: 6/10/2011 Req'd Qty: 1.00



Reference:

Approvals:	Process Plan:	<u>VMR</u>	Date:	11-06-08	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Setup Start



Stop



Cust Item ID:

Customer:

~~PRELIMINARY ISSUE~~

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3210	<u>PB1</u> B 11-06-14	0.00							
100	FLOW WATER JET								
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
<u>2024. 086</u>	1-Cut as per Dwg D3210	<input type="checkbox"/> Dwg Rev: <u>PB1</u>	<input type="checkbox"/> Prog Rev: <u>PB1</u>	<input type="checkbox"/> 2-					
	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC									
Quality Control									
120	QC8- Inspect parts - second check	0.00	-inspected to PB1						
	Memo	0.00	dry only						
QC									
Quality Control									

Ship Friday

Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

WAS

140

Memo
Deburr

0.00

Small Fab

Small Fab

QC

Quality Control

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

K 15 m/pw/06/09

W/O:		WORK ORDER CHANGES							
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Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



Powdercoat

Powder Coating

M115128

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

START TIME:

FINISH TIME:

8:45
0.00□ OVEN TEMPERATURE:
9:15

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

180



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

X P M-1 11/06/04

1 BR 11-6-9

11/6/145

W/O:		WORK ORDER CHANGES							
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Wednesday, June 08, 2011 9:16:11 AM



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Setup

Start



Stop



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Item Name: Doubler

Start Date: 6/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start



Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/6/15 JJ

PRELIMINARY ISSUE MF
11-06-14

POSITIVE RECALL

EFFECTIVE 6/8/08

RELEASED

AUTH U

DATE 6/06/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 08, 2011 9:16:08 AM

Page 1

Work Order ID: 70437



Parent Item: D3210-1B



Parent Item Name: Doubler

Start Date: 6/8/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.07 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased		No			sf	112.1000		0.53		11-6-8	

2024-T3 .080 sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

MAT022	112.1	
105411	6	
109424	4	
110347	0.5	
110908	3	
112331	3	
113796	7	
114025	17.2	
116604	7.8	116604
117392	63.6	

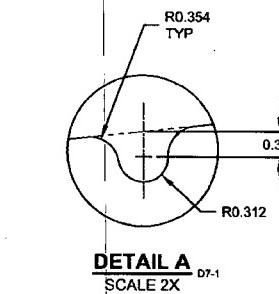
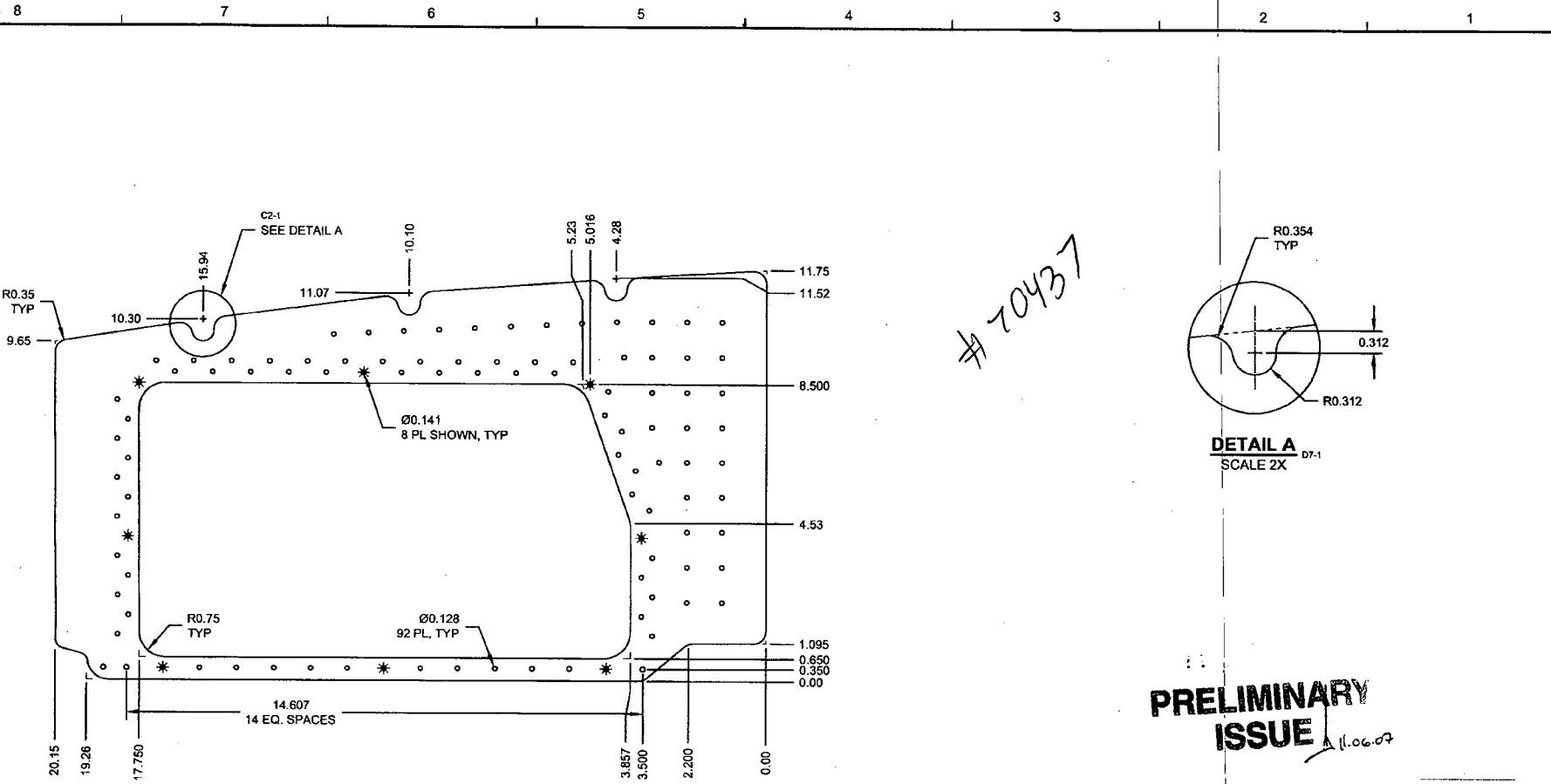
Dart Aerospace Ltd

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PRELIMINARY
ISSUE
11.06.03

PB1	FORMAT TO CURRENT STD; ADD D3210-1B. REASON: PAR11-109.	MB	11.06.03
A	NEW ISSUE	CP	03.09..03
REV.	DESCRIPTION	BY	DATE
DESIGN	DP	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		D3210	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.06.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION AND IS SUBJECT TO RESTRICTIONS ON DISCLOSURE. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

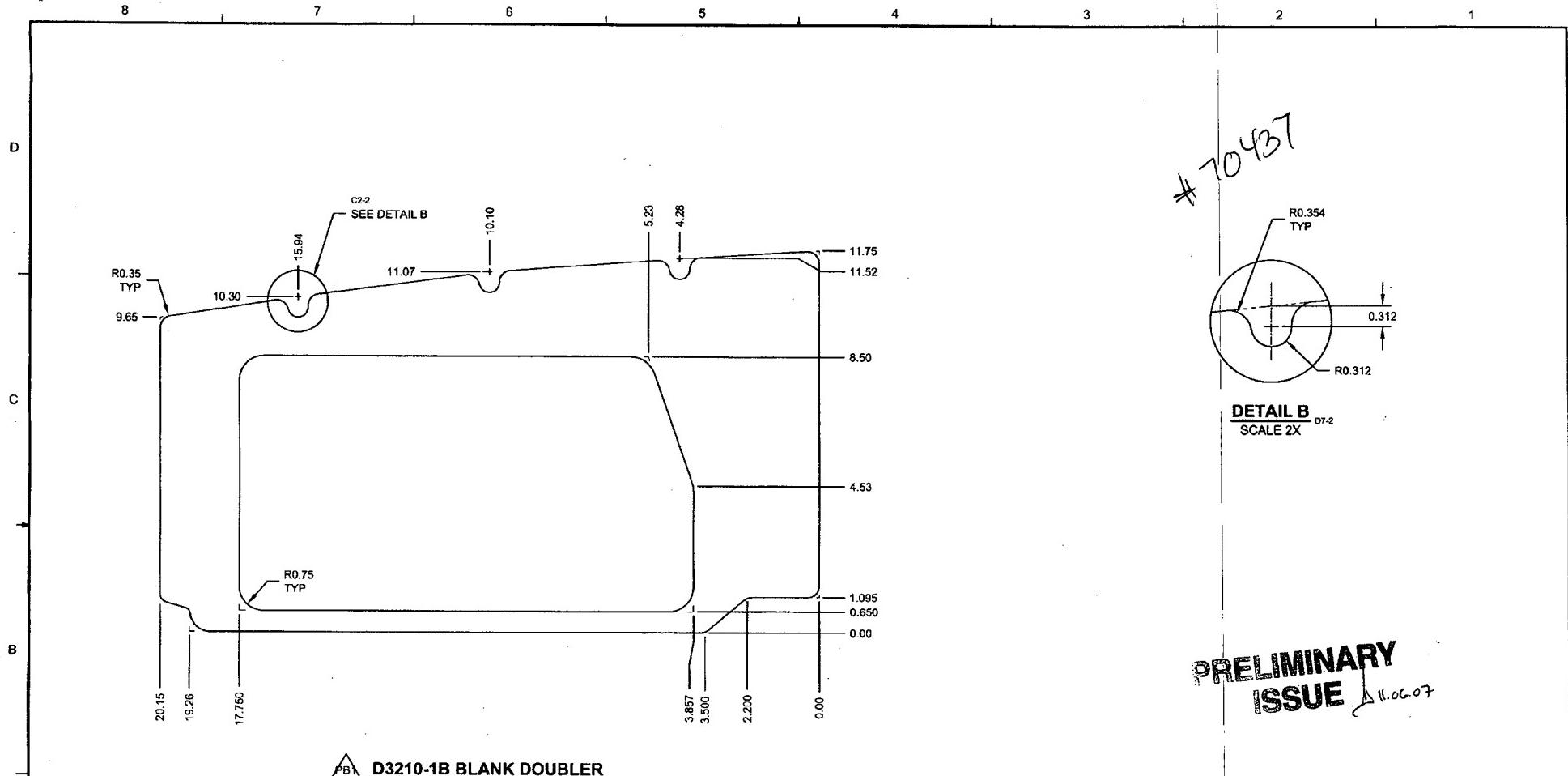
W/O:		WORK ORDER CHANGES						
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8 1 7 6 1 5 4 1 3 1 2 1



DETAIL B D7-2
SCALE 2X

PRELIMINARY
ISSUE 11.06.03



D3210-1B BLANK DOUBLER

D3210-1B NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-1B" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.87 lbs
- 8) MAKE PER "D3210-1B_REV.B.DXF"

DESIGN	90	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. REV. PB1	
MFG. APPR.		D3210 SHEET 2 OF 2	
APPROVED		TITLE SCALE	
DE APPR.		DOUBLER NTS	
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NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 70437

Description: Double

Part Number: D3210-1B

Inspection Dwg: D3310-1B Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: [Signature]

Audited by:

Prototype Approval:

Date: 11-6-9

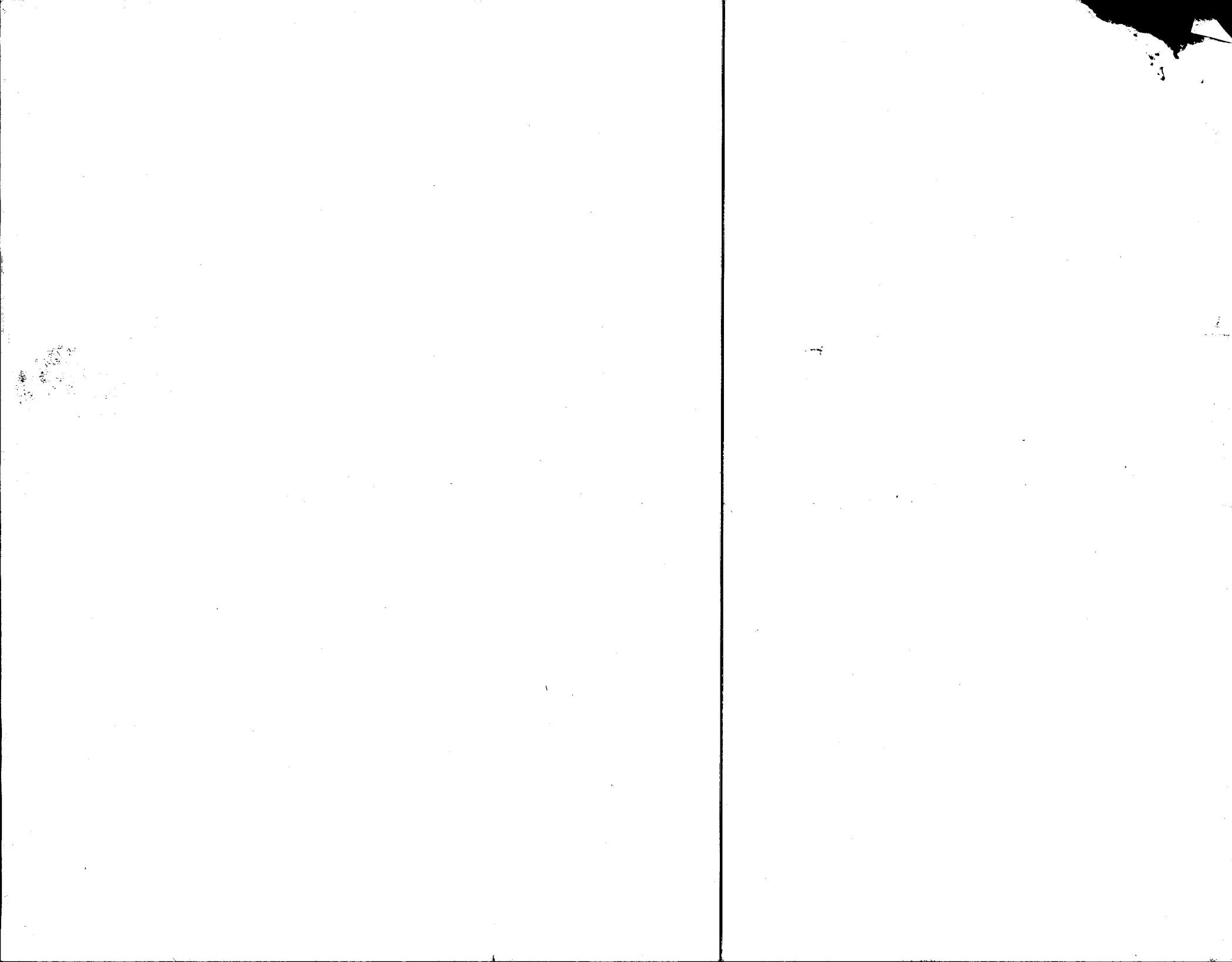
Date: 11/06/08

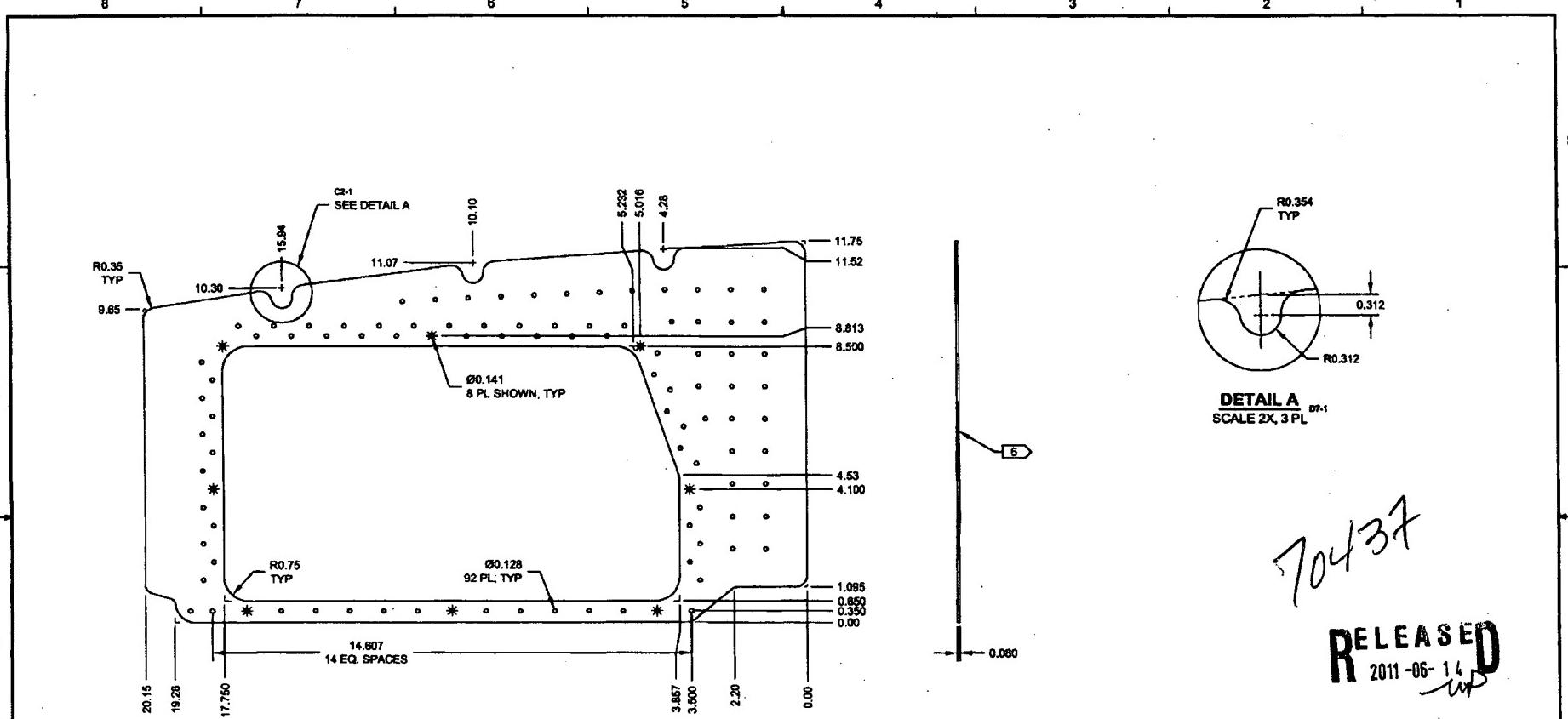
Date:

Rev	Date	Change
A		New Issue

To PBI Day only

Revised by | Approved
K.I.I.M |





B	FORMAT TO CURRENT STD; ADD D3210-1B. REASON: PAR11-109.	MB	11.06.03
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D3210	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
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RELEASED
2011-06-14
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